

thus we please April 10-13

Work Order ID 82782

\*82782\*

April-10-12 7:09:18 AM

Item ID: D4164-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Nut Plate Adapter Assembly

Start Date: 4/10/12 Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 4/11/12 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4164

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D

Dwg Rev: B

Prog Rev: P

2-Deburr if necessary

6061 C.040.

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*[Handwritten signature]*

*[Handwritten signature]* 40  
12-04-10

*[Handwritten signature]* 40  
12-04-10

*[Handwritten signature]* 40

# Work Order ID 82782

**\*82782\***

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**\*40\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

1- Deburr

2-C'sink as per Dwg

140

**\*140\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

141

**\*141\***

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

40x

✓

5/2/04/12

100  
90

5/2/04/10

40

✓

ABD-H-D.

# Work Order ID 82782

**\*82782\***

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April-10-12 7:09:18 AM

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**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

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Item Name: Nut Plate Adapter Assembly

Start Date: 4/10/12 Start Qty: 40.00

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Cust Item ID:

Required Date: 4/11/12 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00


**\*160\***

QC

Memo

0.00

Quality Control

40X 

M.L  
12/04/12

170

Small Fab

0.00

**\*170\***


Small Fab

Memo

0.00

Small Fab

Install Nut plate as per Dwg

40 

GB 12/04/17

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

5/12/17

cc:   
K40

# Work Order ID 82782

April-10-12 7:09:18 AM

**\*82782\***

Page 4

Item ID: D4164-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Nut Plate Adapter Assembly

Start Date: 4/10/12 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 4/11/12 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location

*ST 135*

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

*40X*

*SP  
12-04-18*

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

*12/4/19*

*mf  
12-04-18*

# Picklist Print

April-10-12 7:09:18 AM

Page 1

Work Order ID: 82782

Parent Item: D4164-041

Parent Item Name: Nut Plate Adapter Assembly

Start Date: 4/10/12

Required Date: 4/11/12

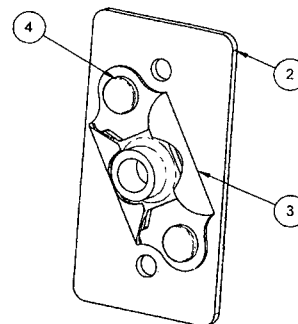
Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	354.9700	0.001	0.0421053		4/12/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT021	354.97						
						121030	84.47						
						121099	270.5						
MS21059L3 Nut Plate		Purchased	No				Each	278.0000		40		4/12/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						302	100						
						121185	100						
						ST301	28						
						118614	8						
						119546	20						
						ST302	150						
						120308	13						
						120833	37						
						121011	100						
MS20426AD3-3 Rivet		Purchased	No				Each	3,927.0000		80		4/12/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST316	3927						
						119109	655						
						121011	2837						
						19099	435						

ITEM	QTY .041	PART NUMBER	DESCRIPTION
1	X	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20426AD3-3	RIVET



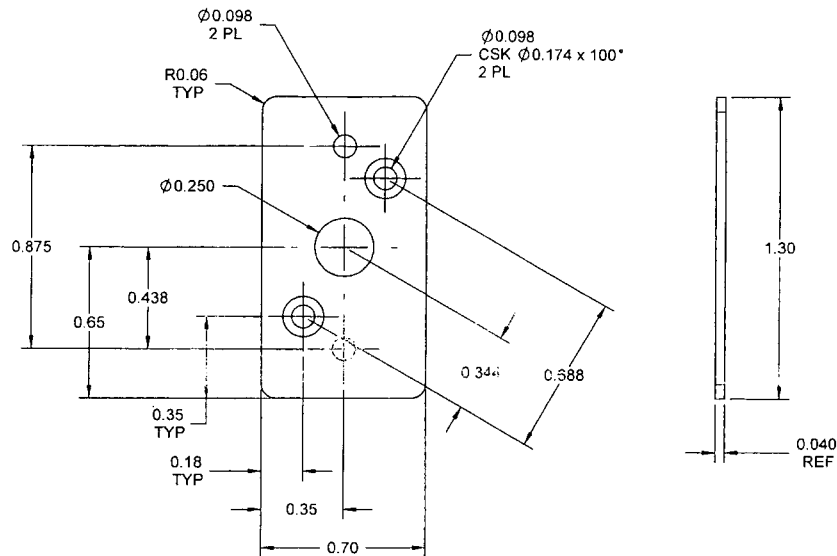
**D4164-041 NUT PLATE ADAPTER ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.006 lbs

**RELEASED**  
2010-09-07  
ND

A	NEW ISSUE	RF	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4164	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	NUT PLATE ADAPTER ASSY	NTS
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**D4164-1 NUT PLATE ADAPTER**

**NOTES:**

- 1) MATERIAL: 6061T6/T62 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
PER DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

**RELEASED**  
2010-09-07

DESIGN	KB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	<b>D4164</b>	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>NUT PLATE ADAPTER ASSY</b>	NTS
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